Product Data Sheet

Corro-Coat PE-F Façade
Series 1301, 1303, 1307 and 1308

Product Description

Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 are exterior durable polyester TGIC powder coatings especially formulated to satisfy the most stringent requirements for colour stability, gloss retention and corrosion protection. Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 provide a uniform flow and finish even after re-cycling.

Application Areas

Primary areas of application are architectural aluminium extrusions and claddings. The overall excellent properties and attractive appearance of Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 make them suitable for application to other ferrous and non-ferrous substrates.

When screen printing or sealants are used, it is advised to run separate trials to ensure compatibility and to meet the required performance criteria.

Pre-treatment

The overall quality of the coating system is largely dependent on the type and quality of the pre-treatment. The recommended types of pre-treatment for the most frequently used substrates are:

Aluminium	Chromate conversion
Steel	Zinc phosphate
Zinc coated steel	Zinc phosphate or chromate conversion
Final rinse (deionized)	The last running water from the object should be tested at 20°C. The readings obtained should measure below 30µS/cm.

Suitable chrome-free pre-treatments for Aluminium are also recommended. Due to the variety of chrome-free pre-treatments available today, only the approved systems from Qualicoat and GSB should be used. Detailed advice should be sought from the pre-treatment supplier.

Curing Schedules

15 minutes at 180°C object temperature
10 minutes at 200°C object temperature
8 minutes at 210°C object temperature

Colour Selection

Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 are available in a wide assortment of custom-made colours and metallic finishes, including RAL and NCS. Corro-Coat PE-F Series 1303, 1307 and 1308 are also available in the Cool Shades Collection, a selection of colours with heat-reflective properties.

Powder Application

Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 are available for Corona or Tribo charging equipment

Product Warranty

Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 are backed by a 10-year product warranty system for exterior application when used on architectural aluminuim substrates, subject to terms and conditions

Storage Conditions

Keep in a dry cool area. Recommended maximum temperature 25°C. Maximum relative humidity 60%. Under these mentioned conditions, product shelf life is 12 months from production date.

Maintenance

Please refer to "*Powder Coated Façades' Maintenance*" document.

Approvals

Please consult your local Jotun Powder Coatings' production unit.

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Technical Data

The technical data provided below are typical for Corro-Coat PE-F Series 1301, 1303, 1307 and 1308 applied to 0.8mm chromated aluminium panels (60-90 micron film thickness). Typical values when tested have not necessarily been recently revised.

Description	Norm	Series 1301	Series 1303	Series 1307	Series 1308
Gloss*	EN ISO 2813 (60°)	12 ± 5	30 ± 5	77 ± 7	90 ± 10
Finish	Visual	Soft Texture	Smooth	Smooth	Smooth
Adhesion	EN ISO 2409 (2 mm)	Cross-cut rating Gt0 (100% adhesion).			
Impact resistance	EN ISO 6272/ASTM D2794 (impactor diameter 15.9 mm)	More than 23 inch-pounds or 2.5Nm without film cracking.			
Cupping test	EN ISO 1520	Indentation depth in excess of 5mm without film cracking			
Flexibility	EN ISO 1519	Cylindrical Mandrel bending test, passes 5mm Mandrel diameter.			
Film hardness	EN ISO 2815	Indentation resistance according to Buchholz: >80.			
Mortar resistance	EN 12206-1	The mortar must be easy to remove without leaving any residues.			
Drilling, milling and sawing test		No flaking of coating.			
Neutral salt spray resistance	ASTM B117	No blistering or loss of adhesion after 1,000 hours.			
Humidity resistance containing SO_2	EN ISO 3231 (0.2 I SO_2)	No infiltration exceeding 1mm on both sides of the scratch after 30 cycles.			
Humidity resistance	EN ISO 6270-2	No infiltration exceeding 1mm on both sides of the scratch after 1000 hours.			
Acetic acid salt spray resistance	ISO 9227	After 1,000 hours testing – maximum 16 mm^2 infiltration over a scratch length of 10cm.			
Accelerated weathering	DIN EN ISO 11507(UVB-313)	Cycle: 4 hours at 50ºC UV and 4 hours at 40ºC condensation. No chalking, excellent gloss retention and colour stability after 300 hours testing.			
Accelerated weathering	DIN EN ISO 11507 (UVA-340)	Cycle: 8 hours at 60ºC UV and 4 hours at 45ºC condensation. No chalking, excellent gloss retention and colour stability after 1000 hours testing.			
Natural weathering test	ISO 2810(South Florida, 27ºN)	No chalking, excellent gloss retention and colour stability after 12 months exposure (angle of 5º to South).			
Surface spread of flame	BS 476 Part 7 – 1997	Class 1			
Fire propagation test	BS 476 Part 6 – 1989	Excellent index of performance (I=1).			
Total Solar Reflectance**	ASTM C 1549	Series 1303, 1307 and 1308: TSR ≥ 0.25			

** If the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample (from the same viewing angle).*

*** Only applicable to Corro-Coat PE-F Series 1303, 1307 and 1308 for the colours featured in the 'Cool Shades Collection'.*

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THIS PRODUCT DATA SHEET SUPERSEDES ALL PREVIOUSLY ISSUED VERSIONS.

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